

Work Order ID 147923

Friday, June 17, 2016 7:56:42 AM

147923

U/R

OK d'19/6/21

Page 1

Item ID: D4095-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Fwd
 Start Date: 6/29/2016 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 7/8/2016 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: ML3 Date: JUN 17 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4095	C

100 0.00

100 FLOW WATER JET

Waterjet Memo 0.11

FLOW CNC Waterjet 1-Cut as per Dwg (D4095-1)

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110 0.00

110 QC2- Inspect parts off machine FAI/FAIB

QC Memo 0.01

Quality Control

120 0.00

120 QC8- Inspect parts - second check

QC Memo 0.01

Quality Control

DAS
38
9-89
JUL 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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DQA: _____ Date: _____



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Work Order ID 147923

Friday, June 17, 2016 7:56:42 AM

147923

Page 4

Item ID: D4095-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Fwd

Start Date: 6/29/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/8/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.01

Quality Control

DAS

38

9-89

AUG 18 2016

200

Identify as per dwg & Stock Location: **FP-002** 0.00***200***

Packaging

Memo

0.01

Packaging

LOCATION : FP002

X4 **c** **HL 16/08/18**

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.07

Quality Control

DAS

21

9-89

AUG 19 2016

DAS

21

9-89

AUG 18 2016

DQA: _____ Date: _____



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Picklist Print

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Page 1

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Parent Item: D4095-041

D4095-041

Parent Item Name: Wearplate Fwd

Start Date: 6/29/2016

Required Date: 7/8/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC
15.10.29 AUTOMATE WELDING DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	242.8172	2.275	9.578947			

M304S16GA

304/316 Sheet .063

Dec 16 / 06 / 23

Location

Loc Qty

Loc Code

MAT010

164.67

m134677

6.07

m134982

158.6

TPI

78.14716

m134604

78.14716

7.5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

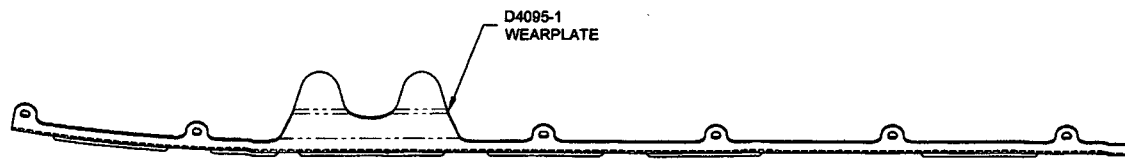
QA Closed: _____ Date: _____

Work Order update only ☐

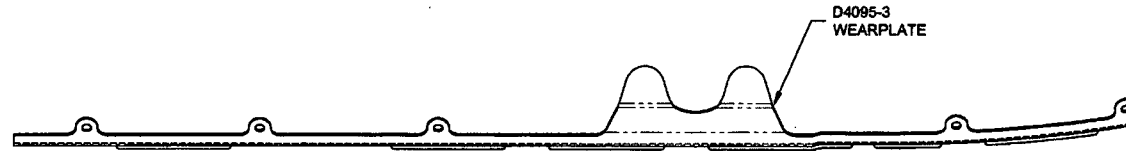
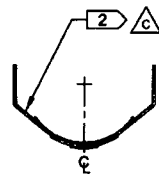
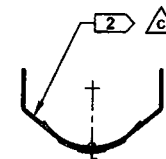
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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 3. BEING
 4. COPIED COPY
 5. DEPARTMENT
 6. NOTICE
 7. ORDER

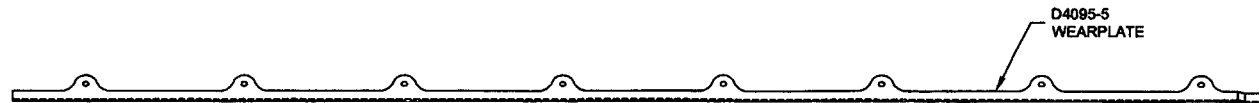
C	B259 WELD ROD WAS 20598, 0.20 WELD THICKNESS WAS 0.25, MOVE DRAIN HOLE IN -1/3, 0.9 WAS 2.00 (TYPO B4-9), ADJUST TOL. FOR MANUFACTURABILITY, NOTE 2 NOW REF'S QSI 005 4.9, UPDATE MAT'L SPEC		CP	16.01.06
B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCK-GUARD REPLACES D4096-1/-3; ADD D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2		XDF	11.10.18
A	NEW ISSUE		MB	10.04.20
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE USA, INC		
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CHECKED		DRAWING NO. D4095	REV. C SHEET 1 OF 9	
MFG. APPR.		TITLE	SCALE	
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DATE	16.01.06			
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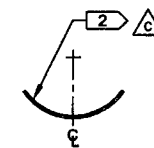
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



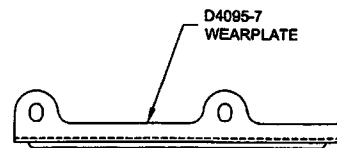
UNDER REVIEW

URF 16-572 ML

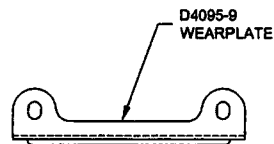
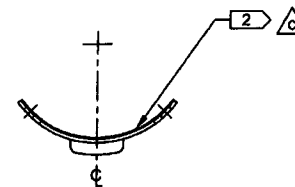
16.05.03

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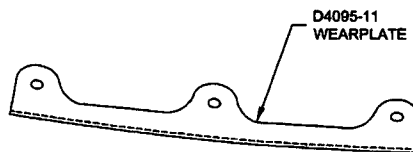
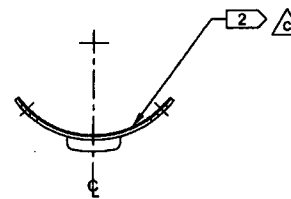
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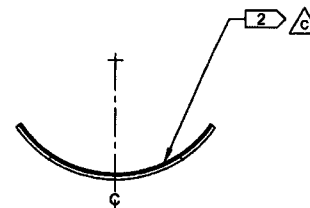
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY



D4095-051 WEARPAD ASSEMBLY

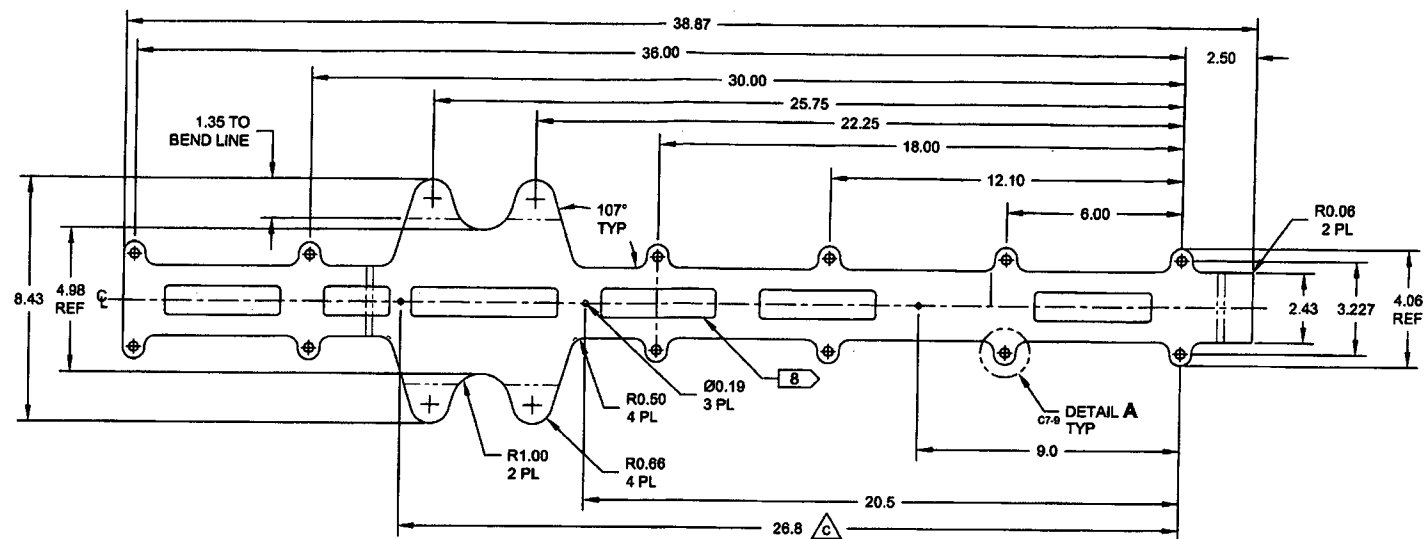


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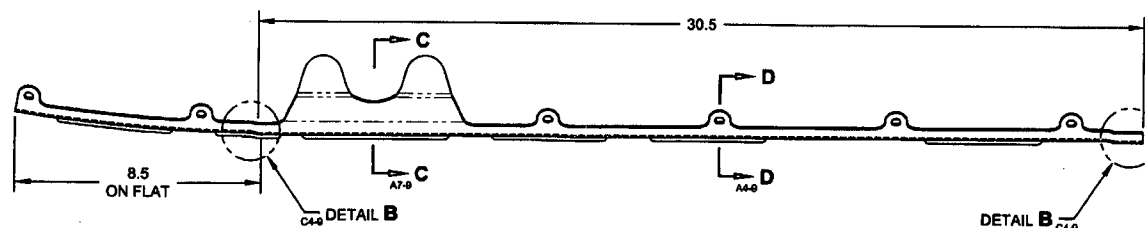
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D4095-1F FLAT PATTERN 1



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240
OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

UNDER REVIEW

URF 16-572 ML

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D4095-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240
OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER Q
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

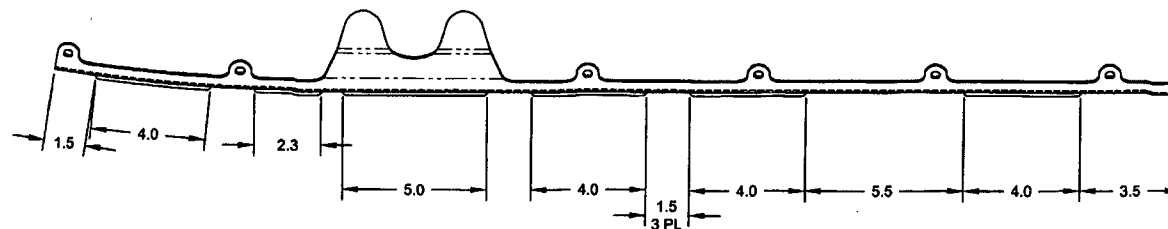
UNDER REVIEW

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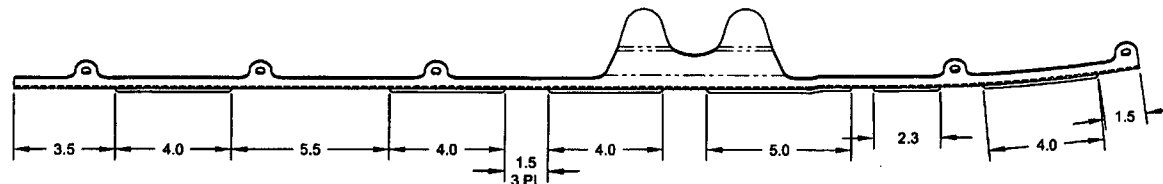
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D4095-1 WELDING DETAIL



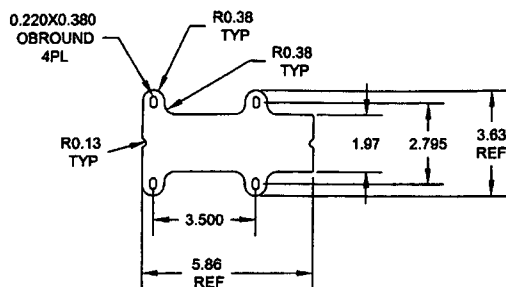
D4095-3 WELDING DETAIL

UNDER REVIEW

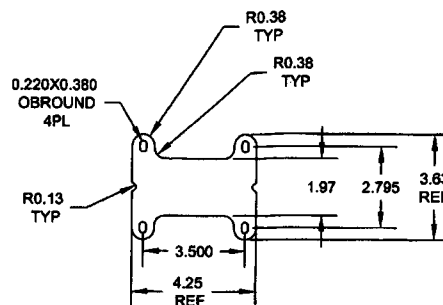
URF 16-572 ML
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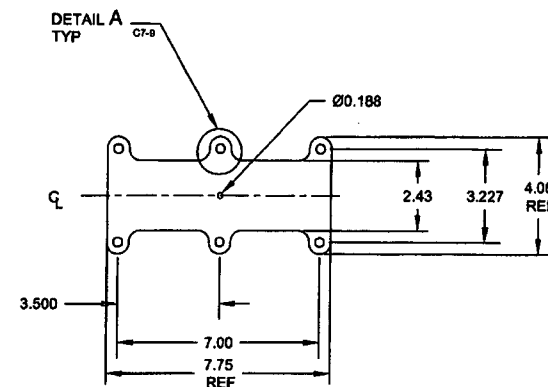
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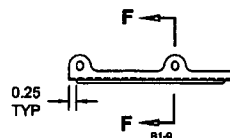
D4095-7F FLAT PATTERN 1



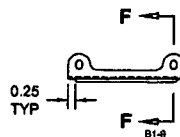
D4095-9F FLAT PATTERN 1



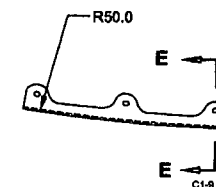
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

D4095-7/-9/-11 NOTES:

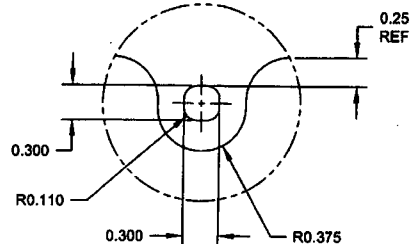
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.083 THICK) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

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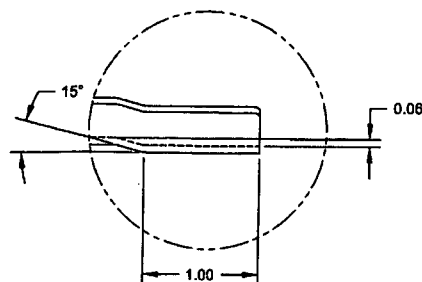
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DETAIL A: TAB DETAIL

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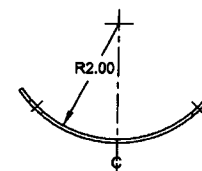
C3-3
C6-6
D3-7
D2-6



DETAIL B: JOGGLE DETAIL

SCALE 4X

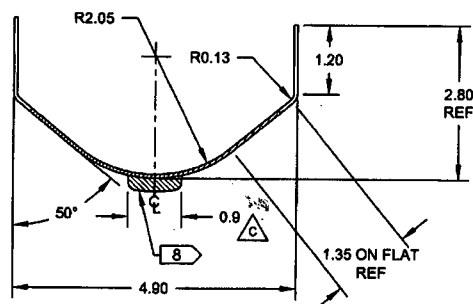
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B6-4
B3-6
B2-7



SECTION E-E

SCALE 2X

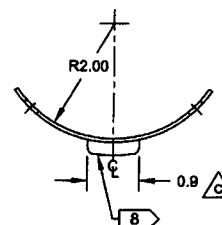
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SECTION C-C

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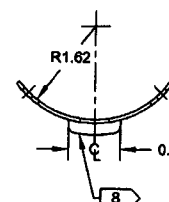
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B4-6



SECTION D-D

SCALE 2X

B4-4
B5-6



SECTION F-F

SCALE 2X

B5-4
B7-8

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